

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler			
2	FD	Touch up tabs & parts from triz inst 112 twin 1 x 0412.664-105 B39534	M	09-07-29	(1)
3	QC3	Inspect	AT	09-07-30	1
4	HK	Repack - ensuring kit is complete using original B/N (re-identify parts)		09/1/30	0
5	QC4	Inspect Kit 100%	S	08/21/38	x1
		@CHG 001 B39534			
6	QC21	Inspect Level 21	DJ	09/09/16	(1)
W. J. R. 16					

Rev	Date	Change	Revised By	Approved

Trial Installations

Product: D205 634 011 B48447 / 47907
D412 664 205 B42773
D412 664 105 B39534

Approx Install time: 4 hrs

IIIN Accurate and Clear? yes

Comments: Return to stock under original.

Kit Complete and Parts Identified

Correctly?

Comments: all complete and well identified

Additional Comments:

All parts fit correctly

Parts require touch up and new hardware

Date: Tuesday, 7/28/09 10:36:57 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 39534	Customer	: Dart Helicopters Services
Estimate Number	: 12816	DWG Name	: 412 X-TUBE INST,LOW NARROW FWD
Purchase Order #	:	Part Number	: D412664105
Complete Date	: 6/06/08 8:44:07 AM	DWG Number	: D412-664-145 REV C
Rev.	: C		

DUE DATE	ORDERED	DELIVERED
6/02/08	1	1

3.0 D412664105TRN-Crosstube Turning Detail	INVENTORY IT
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DATE	EMPLOYEE	TYPE	Qty		COST	
6/06/08	FAUT01: Fauteux, Melanie	D412664105TRN	1.000		\$876.87	Lot # 38012 Qty. 1
Subtotal:	QTD:	0 CTD:	1		\$876.87	

4.0 BENDING	Internal Operation
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DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
5/28/08	MAHE01: Maheu, Andrew	Run	1.000	0.99	\$16.00	0.99	37.28
5/28/08	PAQU03: Paquette, Dan	Run	1.000	3.24	\$61.53	3.24	143.36
5/28/08	LARO01: Larocque, Eric	Run	1.000	3.37	\$54.46	3.37	126.89
Subtotal:	QTD:	3 CTD:	0	7.60	\$439.52		

6.0 CROSSTUBES	Internal Operation
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DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
5/28/08	TITL01: Titley, Ian	Run	1.000	2.27	\$36.68	2.27	85.46
5/29/08	TITL01: Titley, Ian	Run	1.000	0.63	\$10.18	0.63	23.72
5/29/08	TITL01: Titley, Ian	Run	1.000	2.07	\$33.45	2.07	77.94
Subtotal:	QTD:	3 CTD:	0	4.97	\$267.43		

10.0 OUTSIDE SERV.11	Sub-contr./External OP.
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DATE	EMPLOYEE	TYPE	Qty		COST	
6/03/08			1.000		\$132.60	VC-ACU P.O.: PO00006471
Subtotal:	QTD:	0 CTD:	1		\$132.60	

13.0 SPRAY PAINTING	Internal Operation
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DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
6/02/08	MURD02: Murdoch, Matthew	Run	0.000	0.75	\$12.12	0.75	29.45
6/02/08	MURD02: Murdoch, Matthew	Run	0.000	0.25	\$4.04	0.25	9.82
Subtotal:	QTD:	0 CTD:	0	1.00	\$55.43		

15.0 D31893-Chafing Shield	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty		COST	
6/06/08	FAUT01: Fauteux, Melanie	D31893	1.000		\$6.00	Lot # 31656 Qty. 1
Subtotal:	QTD:	0 CTD:	1		\$6.00	

16.0 D3595063450-RUBBER CUSHION	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty		COST	
6/06/08	FAUT01: Fauteux, Melanie	D3595063450	4.000		\$1.91	Lot # 38618 Qty. 4
Subtotal:	QTD:	0 CTD:	4		\$1.91	

17.0 D28931-2.75 Support	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty		COST	
6/06/08	FAUT01: Fauteux, Melanie	D28931	2.000		\$394.63	Lot # 38614 Qty. 2
Subtotal:	QTD:	0 CTD:	2		\$394.63	

Date: Tuesday, 7/28/09 10:36:57 AM
 User: Linda Lacelle

JOB HISTORY : DETAIL

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Estimate Number	: 12816	DWG Name	: 412 X-TUBE INST,LOW NARROW FWD
Purchase Order #	:	Part Number	: D412664105
Complete Date	: 6/06/08 8:44:07 AM	DWG Number	: D412-664-145 REV C
		Rev.	: C

19.0 MS2192024-Clamp(per MIL-DTL-8783C) INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
6/06/08	FAUT01: Fauteux, Melanie	MS2192024	2.000		\$28.73		Lot # 107441 Qty. 2
Subtotal:		QTD:	0	CTD:	2	\$28.73	

20.0 MS2192025-Clamp(per MIL-DTL-8783C) INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
6/06/08	FAUT01: Fauteux, Melanie	MS2192025	4.000		\$107.93		Lot # 107973 Qty. 1 Lot # 107975 Qty. 3
Subtotal:		QTD:	0	CTD:	4	\$107.93	

21.0 CROSSTUBES Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
6/03/08	TITL01: Titley, Ian	Run	1.000	1.74	\$28.12	1.74	69.46
6/05/08	MURD02: Murdoch, Matthew	Run	0.000	1.32	\$21.33	1.32	52.69
Subtotal:		QTD:	1	CTD:	0	3.06	\$171.60

24.0 AN635A-BOLT INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
6/05/08	SAUV02: Sauve, Amy	AN635A	4.000		\$8.76		Lot # 107178 Qty. 4
Subtotal:		QTD:	0	CTD:	4	\$8.76	

25.0 AN636A-Bolt INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
6/05/08	SAUV02: Sauve, Amy	AN636A	4.000		\$8.84		Lot # 107534 Qty. 4
Subtotal:		QTD:	0	CTD:	4	\$8.84	

26.0 MS21042L6-Nut INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
6/05/08	SAUV02: Sauve, Amy	MS21042L6	6.000		\$3.72		Lot # 105077 Qty. 6
Subtotal:		QTD:	0	CTD:	6	\$3.72	

27.0 AN960JD616-Washer INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
6/05/08	SAUV02: Sauve, Amy	AN960JD616	18.000		\$1.27		Lot # 107242 Qty. 18
Subtotal:		QTD:	0	CTD:	18	\$1.27	

		TIME	COST
	Machine Time:	16.63	\$656.07
	Labor:	16.63	\$277.91
	Sub-contract (external Op.):		\$132.60
	INVENTORY ITEM:		\$1438.66
	SUB-COMPONENT (SUB-JOB):		\$0.00
Total:			\$2505.24

COST PER UNIT:		\$2505.24
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32.11.3 LOW-NARROW GEAR CROSSTUBES

Item	-105	-205	Part Number	Description
	X		D412-664-105	CROSSTUBE INSTALLATION, 412 LOW-NARROW FWD
		X	D412-664-205	CROSSTUBE INSTALLATION, 412 LOW-NARROW AFT
4	1		D412-664-145	CROSSTUBE ASSEMBLY, 412 LOW-NARROW FWD
5		1	D412-664-245	CROSSTUBE ASSEMBLY, 412 LOW-NARROW AFT
10	2		* D2893-1	SUPPORT
11	4		* D3595-063-450	RUBBER CUSHION
12	4		* MS21920-25	CLAMP (OR MS21042-26)
13	4		AN6-35A	BOLT
14	4		AN6-36A	BOLT
15	6		MS21042L6	NUT (OR MS21042-6)
16	18		AN960JD616	WASHER
17	1		* D2856-250-842	ABRASION STRIP
18	1		* D3189-3	CHAFING SHIELD
19	2		* MS21920-22	CLAMP
30		1	* D2896-1	SUPPORT
31		2	* D2856-600-1009	ABRASION STRIP
32		2	* D3595-063-570	RUBBER CUSHION
33		4	* MS21920-28	CLAMP
34		2	* MS21920-30	CLAMP (OR MS21042-32)
35		4	AN6-40A	BOLT
36		2	AN6-41A	BOLT
37		6	MS21042L6	NUT (OR MS21042-6)
38		18	AN960JD616	WASHER
39		2	* D3189-1	CHAFING SHIELD
40		2	* D3606-1	CUFF
41		44	* CR3212-4-07	RIVET (M7885/3-4-07)

* REFERENCE ONLY. PARTS ARE INCLUDED IN D412-664-145/-245 ASSEMBLIES ABOVE.

NOTE: KITS INCLUDE EXTRA HARDWARE FOR COMPATIBILITY WITH BOTH DART AND BELL/AA SKIDTUBES.

39534

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